



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D5613-041
Job Sheet 202124



Part No: D5613-041

Job Qty: 4 pcs

Part Name: Midtube Wearplate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/18/19

Job Tracking No:

Due Date: 10/25/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D5613 REV.C IPP REV.A NEW ISSUE 18/10/30 JFS VERIFIED BY: DD IPP REV:B 19.07.30 AS PER DWG
REV.C DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	4 pcs		10/25/19	0.17	0.27	Waterjet - Flow		ac 19/10/21
120	QC 2	4 pcs		10/25/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		ac 19/10/21
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		



Container No: S224606



Part: D5613 - 041

Job No: 202124

Serial No/Batch: S224606

Revision: C

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/23/19

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130	QC 8	4 pcs	10/25/19	0.00 0.00	QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	OCT 22 2019 40
					QC 8 - 52	9-89
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
140	Small Fab - Brake NC - B4B	4 pcs	10/25/19	0.25 0.13	Small Fab - Brake - 1 - B4B	DAS 30 9-89 OCT 22 2019
					Small Fab - Brake - 2 - B4B	
					Small Fab - Brake - 3 - B4B	
150	QC 5	4 pcs	10/25/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
160	Large Fab - Welded Assy-2-B4B	4 pcs	10/25/19	0.00 2.00	Large Fab - 1 - B4B	
					Large Fab - 10 - B4B	
					Large Fab - 2 - B4B	

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					Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	
					Large Fab - 6 - B4B	
					Large Fab - 7 - B4B	
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
					Large Fab - 11 - B4B (Various)	
					Large Fab - 12 - B4B	
170 QC 9	4 pcs	10/25/19	0.00 0.00		QC 9 - 10	
					QC 9 - 18	
					QC 9 - 24	
					QC 9 - 43	
					QC 9 - 50	
					QC 9 - 9	
180 QC 5	4 pcs	10/25/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
190 Handfinish - 4-1-Assembly-B4B	4 pcs	10/25/19	0.00 0.67		Handfinish - 4 - 1 - B4B	 41 9-89 OCT 24 2019
					Handfinish - 4 - 10 - B4B	
					Handfinish - 4 - 11 - B4B	
					Handfinish - 4 - 12 - B4B	
					Handfinish - 4 - 13 - B4B	
					Handfinish - 4 - 14 - B4B	
					Handfinish - 4 - 15 - B4B	
					Handfinish - 4 - 2 - B4B	
					Handfinish - 4 - 3 - B4B	
					Handfinish - 4 - 4 - B4B	
					Handfinish - 4 - 5 - B4B	
					Handfinish - 4 - 6 - B4B	
					Handfinish - 4 - 7 - B4B	
					Handfinish - 4 - 8 - B4B	
					Handfinish - 4 - 9 - B4B	
200 QC 3	4 pcs	10/25/19	0.00 0.00		QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	

			QC 3 - 34	
			QC 3 - 36	
			QC 3 - 41	
			QC 3 - 51	
			QC 3 - 58	
			QC 3 - 59	
			QC 3 - 68	
			QC 3 - 9	
			QC 3 - 40	OCT 2 5 2019 ^{DAS} 40 ₉₋₈₉
			QC 3 - 19	
			QC 3 - 43	
			QC 3 - 24	
			QC 3 - 61	
			QC 3 - 81	
210 Packaging 3-1 - Stock - B4B	4 9 pcs	10/25/19	0.00 0.00	Packaging 3 - 1 - B4B
				Packaging 3 - 2 - B4B
				Packaging 3 - 3 - B4B ✓
				Packaging 3 - 4 - B4B
				Packaging 3 - 5 - B4B
				Packaging 3 - 6 - B4B
				Packaging 3 - 7 - B4B
				Packaging 3 - 8 - B4B
				Packaging 3 - 9 - B4B
				Packaging 3 - 10 - B4B
				Packaging 3 - 11 - B4B
				Packaging 3 - 12 - B4B
				Packaging 3 - 13 - B4B
				Packaging 3 - 14 - B4B
				Packaging 3 - 15 - B4B
				Packaging 3 - 16 - B4B
				Packaging 3 - 17 - B4B
				Packaging 3 - 18 - B4B
				Packaging 3 - 19 - B4B
				Packaging 3 - 20 - B4B
				Packaging 3 - 21 - B4B
				Packaging 3 - 22 - B4B
				Packaging 3 - 23 - B4B
				Packaging 3 - 24 - B4B
				Packaging 3 - 25 - B4B
				Packaging 3 - 26 - B4B
				Packaging 3 - 27 - B4B
				Packaging 3 - 28 - B4B
				Packaging 3 - 29 - B4B
				Packaging 3 - 30 - B4B
				Packaging 3 - 31 - B4B
				Packaging 3 - 32 - B4B
				Packaging 3 - 33 - B4B
				Packaging 3 - 34 - B4B
				Packaging 3 - 35 - B4B
				Packaging 3 - 36 - B4B
220 QC 21 - SA	4 9 pcs	10/25/19	0.00 0.00	QC 21 - SA - 21 ✓
				QC 21 - SA - 70
				QC 21 - SA - 53
Part Op 110 - 1-Cut D5613-1F as per Dwg D5613 Dwg Rev: <u>C</u> Prog Rev: <u>C</u> 2-Deburr if necessary Descriptions: 120 - QC2- Inspect parts off machine FAI/FAIB 130 - QC8- Inspect parts - second check 140 - Form as per dwg 150 - QC5- Inspect part completeness to step on W/O 160 - ***ENSURE WELDED CLAMP FITS AROUND A 3.620" DIAMETER WITH 0.375-0.500 THREAD EXPOSED WHEN SNUG.*** 1- Weld per dwg A/R S.S. rod Batch: <u>M136585</u> 2- Install nut hand tight only AFTER WELDING				

170 - QC9- Inspect visual per QSI004- Fusion Welds

180 - QC5- Inspect part completeness to step on W/O

190 - Assemble as per dwg - ***MASK CLAMP PRIOR TO TEXTURED COATING*** 1- APPLY TEXTURED COATING ON CONCAVE SURFACE ****AS PER NOTE 2**** ON DWG AND QSI005 4.9 BATCH: 4136585 3217452

200 - QC3- Inspect Part Finish

210 - Identify as per dwg & Stock Location: _____

220 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	8.1200 sf (2.03 ea)	110-Waterjet - Flow - 1	
D5617-1	Clamp	8 pcs (2 ea)	160-Large Fab - Welded Assy-2- B4B	<u>5225308</u>
D5678-1	Hex Nut	8 pcs (2 ea)	160-Large Fab - Welded Assy-2- B4B	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	M304S16GA	8	372	0
160-Large Fab - Welded Assy-2- B4B	D5617-1	8	14	0
	D5678-1	8	6	0

Part Specifications

Specifications could not be found.

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Aug. 10-21

202129

DAS
40
9-89

9-89

Date:

Revised by
KJ

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only



Job: _____		DISPOSITION		DEPARTMENT/PROCESS		MRB (QS1042)			
Part No. _____		Rework Scrap Use-as-is		Cross tube Small Fab Finishing		Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging		Engineering Water Jet Supplier Quality	
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QS1042)			
Description Work Order Deviation		Disposition							
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors		FAULT CATEGORY							
		Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabelled Other/Details:		Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function		Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up		Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread	
								Completed By	
								Lead hand / Supervisor	
								QC / QA Coordinator	